

Work Order ID 158436***158436***

Page 1

Wednesday, March 22, 2017 2:17:30 PM

Item ID: 647.4313

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: RH Upper Strut

Start Date: 3/27/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 4/12/2017 Req'd Qty: 8.00

8

Customer:

Reference: SCHEDULED

DAS
21
9-89Run Start ***NR1***

Approvals: Process Plan:

Date: MAR 22 2017

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.4300

A

110

0.05

110

Waterjet

FLOW CNC Waterjet

Memo

0.13

1-Cut 647.4312 plate 3.928X1.985 as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

8 DAS
46
9-89 17/03/24

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.08

8 DAS
46
9-89 17/03/24

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Page 2

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.16

Quality Control

MAR 27 2017

140

0.00

140

Small Fab

Memo

2.39

Small Fab

1- Fabricate tube as per dwg by cutting (22.00") one end 27.7 degree and other end punch, bend and drill hole as per dwg

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.16

Quality Control

APR 05 2017

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Page 3

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Customer:

Reference: SCHEDULED

Run Start ***NR1***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Weld per dwg A/R S.S. rod Batch: <u>1134442</u>	0.00							
Large Fab	Memo Weld tube to plate as per dwg. Weld end were tube is punch.	0.40						<u>DYC</u> <u>17/04/05</u>	
170 *170* QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	Memo	0.00						<u>17-04-06</u>	<u>DAS</u> <u>9</u> <u>9-89</u>
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.16						<u>12-04-06</u>	<u>DAS</u> <u>9</u> <u>9-89</u>

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Page 4

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Cust Item ID:

Required Date: 4/12/2017 Req'd Qty: 8.00

8

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00

190

SprayPaint

Memo

1.99

Prime as per dwg (see note 4)

Batch: 137220

200

QC14- Inspect Spray Paint

0.00

200

QC

Memo

0.08

Quality Control

210

0.00

210

Packaging

Memo

0.00

***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND
REV***

ST 8X SP174-20
CCK075

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Page 5

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8

Customer:

Reference: SCHEDULED

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.80

Quality Control

17/4/24 DAS
21
9-89

APR 29 2017

Picklist Print

Page 1

Wednesday, March 22, 2017 2:17:42 PM

Work Order ID: 158436

158436

Parent Item: 647.4313

647 4313

Parent Item Name: RH Upper Strut

Start Date: 3/27/2017

Required Date: 4/12/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.06 CHG MATERIAL TO S.S. DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			110	sf	40.0000	0.054	0.454737	DAS 46 9-89	17/03/24	
M304S16GA									**				

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT010	40	
m136790	2.1	
m136896	5.9	0.5
m137110	32	

M304TR0.500W.049

Purchased

No

140

f

40.0466

1.83

15.41053

M304TR0 500W 049

304 RD Tube .500 x .049W

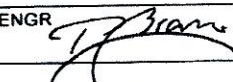
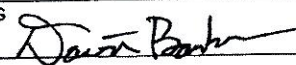
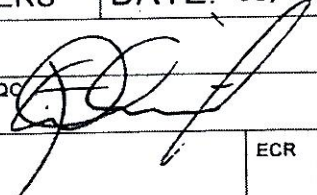
**

DYC 17/04/04

Location	Loc Qty	Loc Code
GA002	40.046573	
M127937	1.1741	
M132872	4.589736	
M136569	6.282737	
M136846	8	
M137091	20	

M137169

15.333

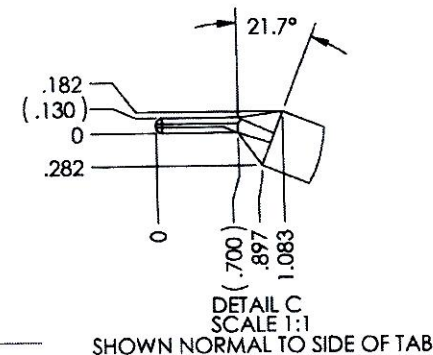
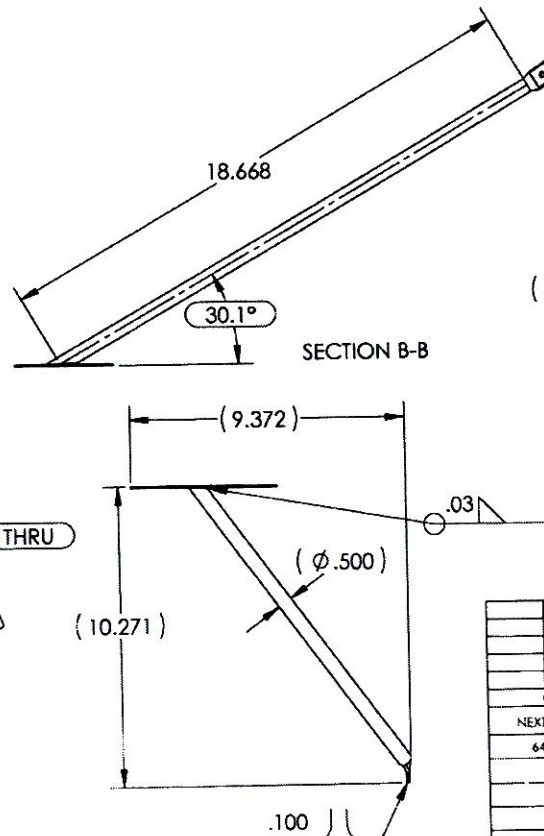
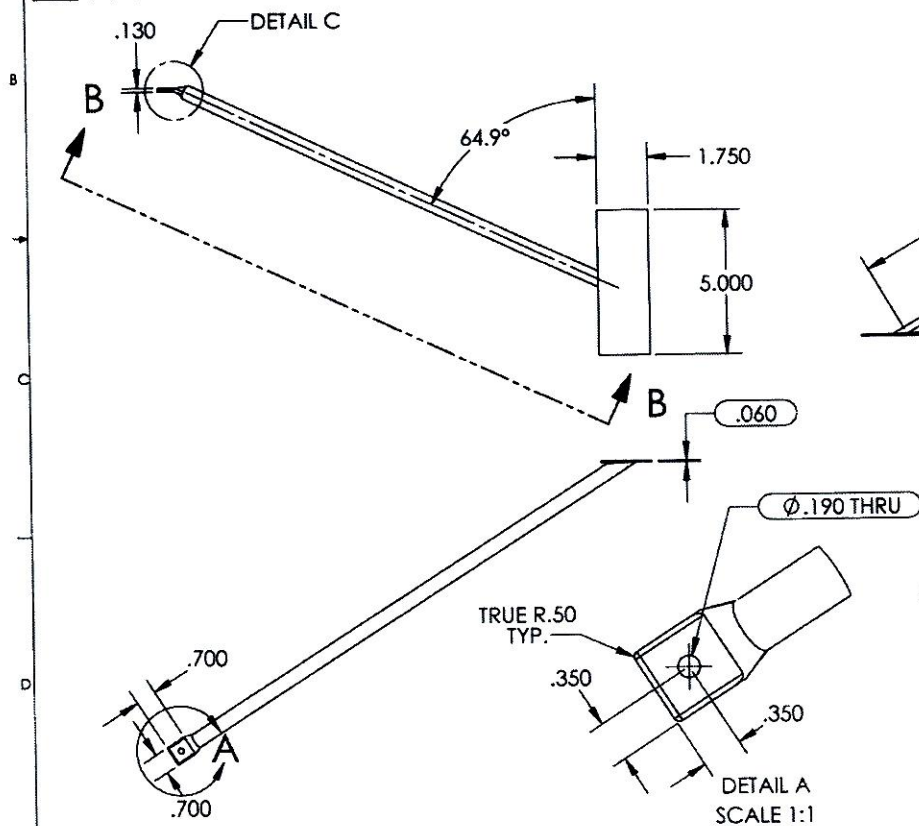
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 04048					SHEET 1 OF 1	
	DWG NO. 647.4300		REV: N/C	PREPARED BY D. PETERS	DATE: 08/12/13		EFFECT ON DWG ☒ INC. ☐ UNINC.
	DWG TITLE: STRUT						
	APPROVED BY: ENGR 	MFG 	QC 	EFF NEXT ORDER			
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: MARKED INSPECTION DIMENSIONS					ECR NONE	
SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. <u>158436 MW</u> 1703-22							
DOCUMENTS EFFECTED: ☐ RFMS ☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM					CHANGE CATEGORY ☐ MAJOR ☒ MINOR		DER REVIEW REQUIRED ☐ YES ☒ NO

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NOTES: UNLESS OTHERWISE SPECIFIED

1. MATERIAL: 4130 STEEL PER AMS-S-18729, .06" THK.
2. MATERIAL: 4130 STEEL PER AMS-S-18729, .13" THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .049" WALL THK.
4. FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD.

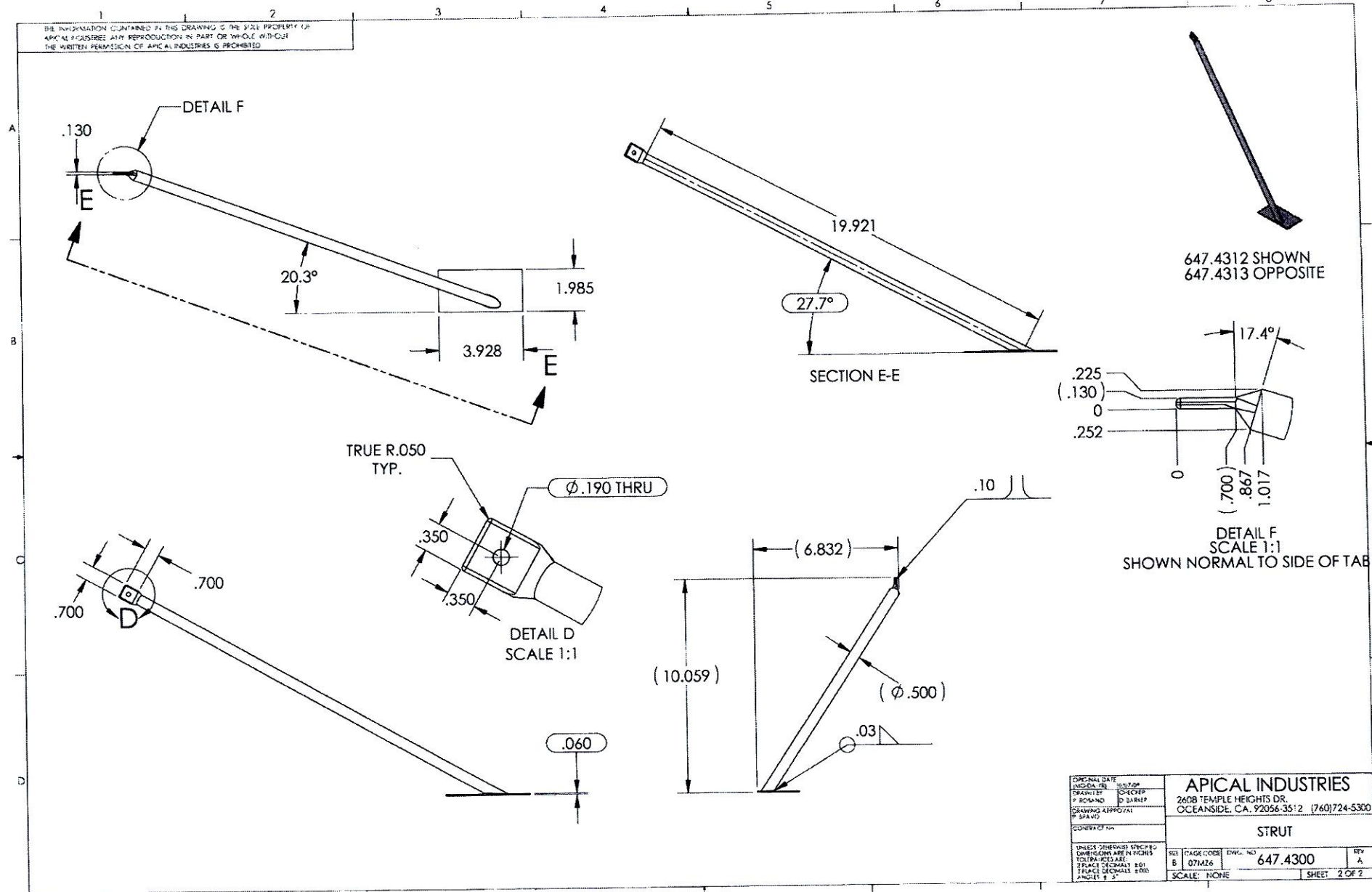
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR1		
N/C	INITIAL RELEASE	10/07/09	P. BRAVO
A	INCORPORATED ECN 04048	08/12/13	P. BRAVO



647.4310 SHOWN
647.4311 OPPOSITE

PARTS LIST			
QTY	DESCRIPTION	MATL	SPEC.
	647.4313 RH UPPER STRUT	△△△	△△△
	647.4312 LH UPPER STRUT	△△△	△△△
	647.4311 RH LOWER STRUT	△△△	△△△
	647.4310 LH LOWER STRUT	△△△	△△△
STRUT			
NEXT ASSY (S)		647.4300	
ORIGINAL DATE		DATE	
DRAWN BY		CHECKED BY	
BY		ID	
DESIGN APPROVAL		DATE	
CONTRACT NO.		SCALE	
UNLESS OTHERWISE SPECIFIED		TOLERANCES ARE IN INCHES	
FRACTIONS		3 PLACE DECIMALS ±.005	
ANGLES		4° 5'	
REV		REV	
B		A	
SCALE		NONE	
SHEET		1 OF 2	

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647.4312 SHOWN
647.4313 OPPOSITE

ORIGINAL DATE		APICAL INDUSTRIES	
DESIGNED BY	W. J. FORD	2608 TEMPLE HEIGHTS DR.	
DRAWN BY	P. ROMANO	OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKED BY	D. BARNETT	STRUT	
DRAWING APPROVAL	P. SPANO	SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS .001 ANGLES .5°		SHEET	2 OF 2